

Slit

Now

Work Order ID 77850

\*77850\*

December-22-11 8:19:49 AM

Item ID: D4093-3      Accept      \*N900040100\*      Setup Start \*NS1\*  
Revision ID:      Stop \*NS2\*  
Item Name: Bracket      (4)  
Start Date: 22/12/2011      Start Qty: 16.00      \*16\*      Cust Item ID:  
Required Date: 05/01/2012      Req'd Qty: 16.00      \*16\*      Customer:  
Reference:

Approvals:      Process Plan: M.L.J      Date: 11/12/22      Tooling:      Date:      Run Start \*NR1\*  
QC:      Date:      SPC (Y/N):      Date:      Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4093	C

110		0.00							
*110*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT AS DWG								
	DWG REV: E								
	PROG REV: E								
	DEBURR								

1311-12-28

(16)

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

1311-12-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77850

December-22-11 8:19:49 AM

**\*77850\***

Page 2

Item ID: D4093-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 22/12/2011 Start Qty: 16.00 **\*16\*** Cust Item ID:  
 Required Date: 05/01/2012 Req'd Qty: 16.00 **\*16\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		S 11/12/28		(+4)			
132 <b>*132*</b> Small Fab Small Fab	Memo DRILL AS PER DWG	0.00 0.00		11/12/28		4			
135 <b>*135*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		S 11/12/27		(+4)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Work Order ID 77850

**\*77850\***

Page 3

December-22-11 8:19:49 AM

Item ID: D4093-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 22/12/2011 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: **5124**

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

*[Signature]*

**(4)**

11-12-29

*[Signature]* 11/12/29 **(4)**

*[Signature]* 11/12/29 **(4)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 77850****\*77850\***

Page 4

Item ID: D4093-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bracket

Start Date: 22/12/2011 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

CK 12/01/02

11-12-29  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

Page 1

December-22-11 8:19:55 AM

Work Order ID: 77850

\*77850\*

Parent Item: D4093-3

\*D4093-3\*

Parent Item Name: Bracket

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 10-10-04 JLM VERIFIED BY:DD IPP  
REV:B AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD IPP  
REV:B AS PER REV C 11.09.28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No				f	42.6600		16			

\*M6061T6B0 750X06 000\*

6061T6 BAR .750 X 6.00

\*\*

B11-12-28

Location

Loc Qty

Loc Code

MAT003

42.66

112567

18.66

119231

24

119231

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

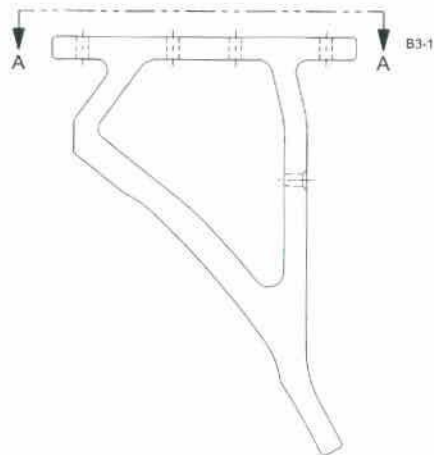
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

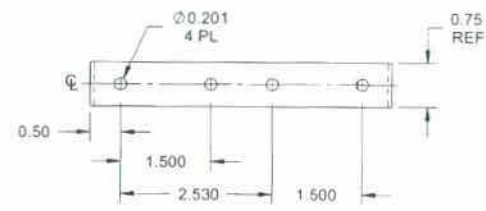
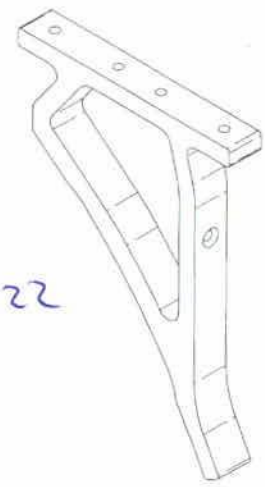
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





STUDY  
 REF. REVISION  
 ENGINEERING  
 UNCONTROLLED  
 SUBJECT TO REVISION  
 WITHOUT NOTICE  
 WORK IN PROGRESS  
 NO. 77850 M.L.J  
 11/12/22



SECTION VIEW A-A D6-1

RELEASED  
 2011-09-22

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
 OR ASTM B211 OR ASTM B221  
 OR 6061-T6/T62 ALUMINUM SHEET  
 PER QQ-A-250/11 OR AMS-QQ-A-250/11  
 OR AMS 4025 OR AMS 4027  
 OR ASTM B209  
 REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.54 lbs

D4093-1 BRACKET

C	REDRAWN D4093-1-3 (ZN B4-1, B4-2). ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5)	RF	11.07.27
B	REDRAWN D4093-1-3 (ZN B4-1, B4-2)	RF	11.01.31
A	NEW ISSUE	RF	10.09.16
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	1/0	DRAWING NO.	REV. C
MFG. APPR.	8/1	D4093	SHEET 1 OF 5
APPROVED	1/0	TITLE	SCALE
DE APPR.	1/0	BRACKET	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

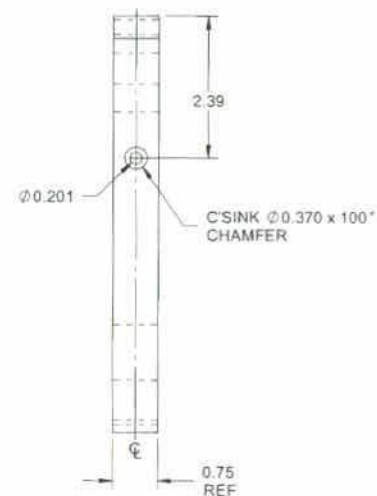
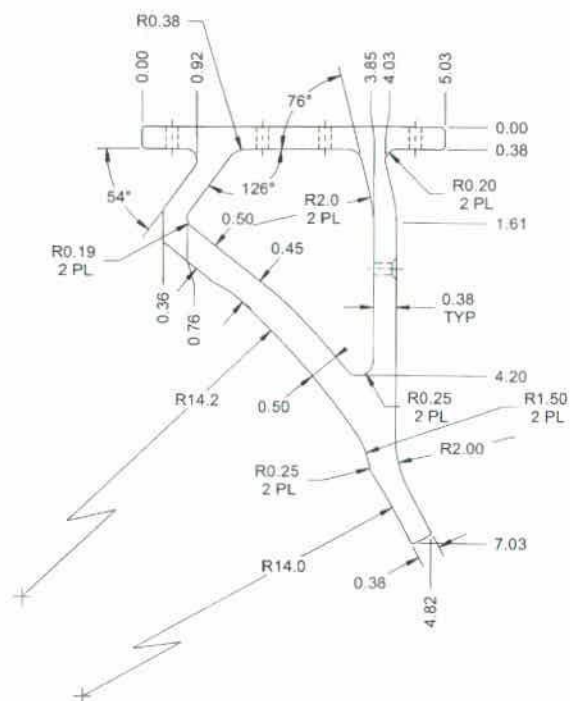
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

77850



D4093-1 BRACKET

**RELEASED**  
2011-09-22  
*WMD*

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4093	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

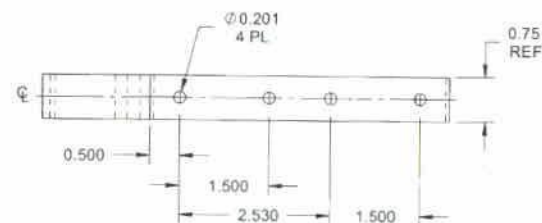
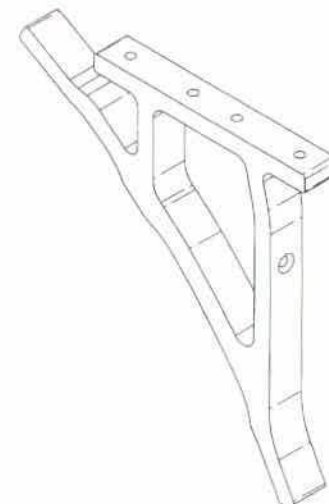
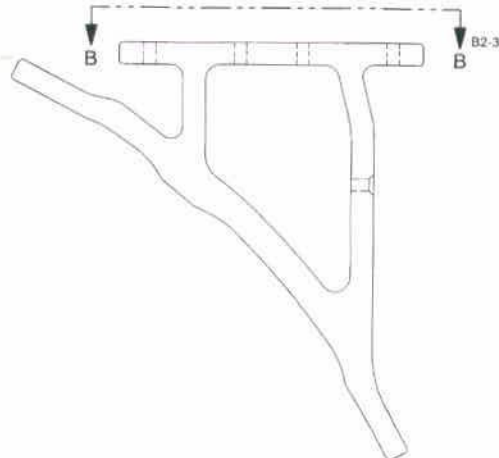
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

77850



D4093-3 BRACKET

SECTION VIEW B-B B5-3

RELEASED  
2011-09-22

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
OR 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>RF</i>	D4093	SHEET 3 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BRACKET	NTS
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W/O:		WORK ORDER CHANGES					
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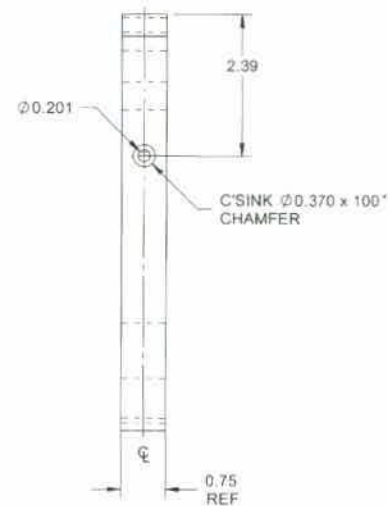
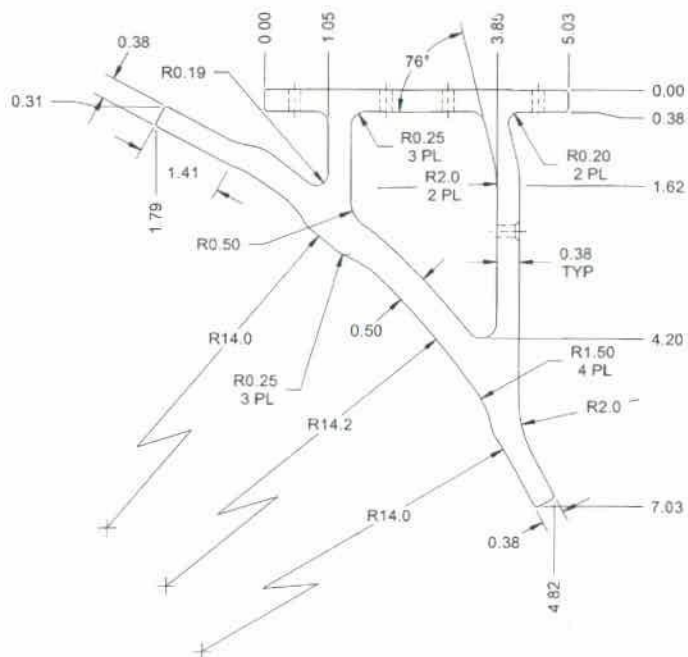
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D4093-3 BRACKET 

RELEASED  
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO	REV. C
MFG. APPR.	<i>RF</i>	D4093	SHEET 4 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

77850



**D4093-5 BRACKET**

**NOTES**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
OR 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

**RELEASED**  
2011-09-22

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO <b>D4093</b>	REV. C SHEET 5 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	<b>BRACKET</b>	NTS
DE APPR.	<i>[Signature]</i>	DATE <b>11.07.27</b>	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD

Work Order: 77850

Description: BRACKET

Part Number: 4093-3

Inspection Dwg: 4093 Rev: C

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.39	$\pm .030$	2.396	—		31006	Height Gauge
$\phi .201$	$\pm .005$	$\phi .202$	—		RA26	Jern
.370x100°	$\pm .010 \pm 1/2$				"	
.500	$\pm .010$	.502	—		RA26	
1.500	$\pm .010$	1.501	—		"	
2.530	$\pm .010$	2.531	—		"	
1.500	$\pm .010$	1.502	—		RA26	Jern

Measured by: 

Date: 11/12/28

Audited by: 

Date: 11/12/28

Prototype Approval:

Date:

Rev	Date	Change
A		New Issue

Revised by	Approved
KJULM	